

Date: Tuesday, 23/12/2008 3:30:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : JACK SADDLE
 Job Number : 44318
 Estimate Number : 11177
 P.O. Number :
 This Issue : 23/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2281
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D2281 REV G
 Previous Run : 43742 Project Number : N/A
 Material :
 Due Date : 20/01/2009 Qty: 100 Um: Each
 Written By :
 Checked & Approved By : UMF 08-12-24
 Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM
 Est: rev B 06.07.17 waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S14GA 304SS sheet .080



Comment: Qty.: 0.1313 sf(s)/Unit Total: 13.1250 sf(s)

304SS .080 109358

batch: 109358 IB 9-1-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G

IB 9-1-14

2-Deburr if necessary IB 9-1-14

110

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 9-1-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

center
 02/01/15 (+110)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Deburr

1/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 3:30:39 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 44318

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SP 09/12/15 (110)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
SP 09/12/15 (+110)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

State Can

9/1/15

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/16

Job Completion



MR 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44318
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.471	x			
4.114	+/-0.010	4.113	x			
2.933	+/-0.010	2.933	x			
1.535	+/-0.010	1.534	x			
0.354	+/-0.010	0.354	x			
0.354	+/-0.010	0.354	x			
0.604	+/-0.010	0.604	x			
2.000	+/-0.010	2.000	x			
3.396	+/-0.010	3.397	x			
3.646	+/-0.010	3.646	x			
4.000	+/-0.010	4.004	x			
1.525	+/-0.010	1.524	x			
2.475	+/-0.010	2.479	x			
Ø0.323	+0.006/-0.001	0.324	x			
0.080	+/-0.010	0.074	x			

Measured by:	RB
Date:	9-1-14

Audited by:	S
Date:	09/01/15

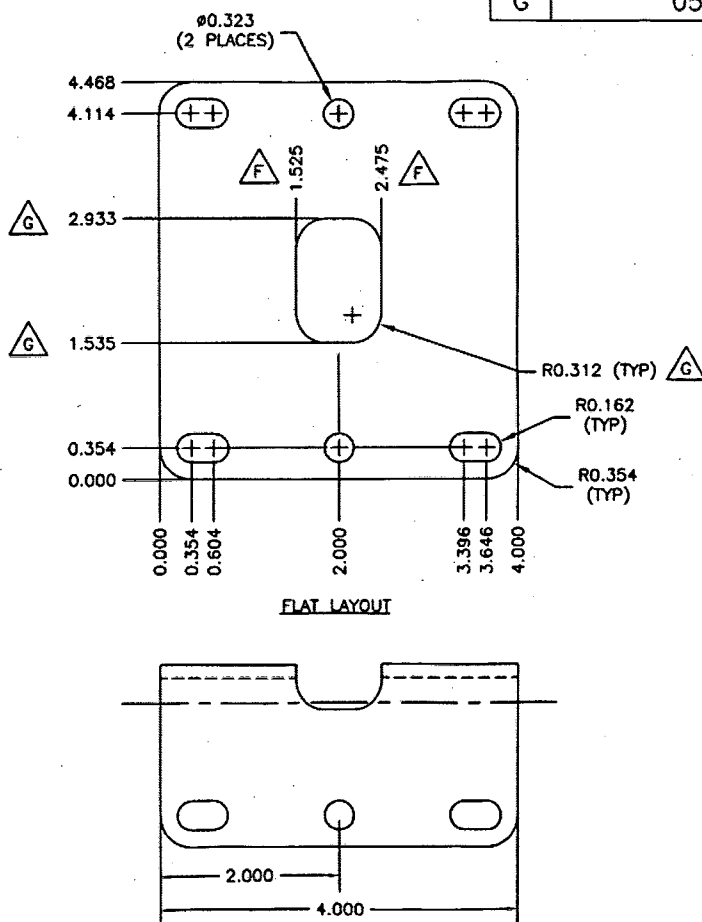
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

DART**RELEASED**

05/08/11

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44318

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